

WORK ORDER 2011-05

Date opened: 21 January 2011

Project: Quick Release Cargo Basket Assembly
Type: Robinson R44 SeriesBatch Quantity: 1 Complete RH Basket Assembly (90610-01-01)
Stainless Steel PrototypeApproval: SH10-48
Drawing List: DCL906-11, DCL906-12

Fabrication and Assembly Drawing(s)	Description
90610, Rev. 0	Basket Ass'y
90611, Rev. 0	Basket Body Ass'y
90612, Rev. 0	Basket Lid Ass'y
84255, Rev. 0	Handle Installation
84261, Rev. 0	Handle Bar Ass'y
84262, Rev. 0	Handle Bracket Ass'y

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u>
Document Control List revision level matches (or exceeds) STC:	<u>Y</u>
Drawings revision levels match Document Control List:	<u>Y</u>
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u>
Tests and inspections specifically called out on drawings are complete:	<u>Y</u>
Release tags associated with all fabricated parts are attached:	<u>Y</u>
All mounting hardware and supplies are included:	<u>Y</u>

List all non-conformities raised: _____

Welder Signature: _____ Date: _____

Inspector Signature: _____ Date: _____

Drawing: 90610 Revision 0
 Assembly: 90610-01 Cargo Basket Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
1 Total	90610-01-01	RH Cargo Basket Assembly			
1	90611-01	Basket Body Assembly	Below		
1	90612-01	Basket Lid Assembly	Below		
1	84255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace	8093	
1	MS20001P4	Piano Hinge		11014	
1	90627-01	Placard	0.063" Sheet, 6061-T6 Aluminum	10086	
3	49205-14	Bumper	Argus Industries Bumper	11010	
A/R	HR3213-5-02	Blind Rivet		10089	
4	HR3523-5-02	Monel Blind Rivet		11061	
3	40088-14	Fitting	Ancra	11012	
3	AN960-616	Washer		11077	
1	90628-01	Fitting			
1	AN3-15A	Bolt		7077	
1	AN3-17A	Bolt		10125	
4	AN960-10	Washer		11028	
2	AN970-3	Washer		11052	
2	MS21044N3	Nut		11028	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	HR3213-5-02, HR3523-5-02 Rivets		
Final Inspection	Drawing 90610			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 90611 Revision 0
 Assembly: 90611-01 Basket Body Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
1 Total	90611-01-01	RH Basket Body Assembly			
1	90621-01-01	RH Aft Attachment Hoop			
2	90621-04	Lug	304 Stainless Mild Steel, 5/8" Rod	9501112	
1	90622-01-01	RH Forward Attachment Hoop	304 Stainless Steel, 1/2" x 0.035 Sqr. Tube	10128	
2	69823-02	Lug	304 Stainless Mild Steel, 5/8" Rod	9501112	
3	49210-02	Hoop	304 Stainless Steel, 1/2" x 0.035 Sqr. Tube	10128	
A/R	--	Tube	304 Stainless Steel, 1/2" x 0.035 Sqr. Tube	10128	
A/R	--	Tube	304 Stainless Steel, 3/4" x 0.035 Sqr. Tube	10128	
1	84262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	304 Stainless Steel, 1/2" Rod	8096	
A/R	3/4-16F	Mesh	Expanded carbon steel	10001	
			stainless		

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 90611			
Final Inspection	Drawing 90611			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 90612 Revision 0
 Assembly: 90612-01 Basket Lid Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
1 Total	90612-01-01	RH Basket Lid Assembly			
A/R	69824-01	Tube	304 Stainless Steel, $\frac{3}{4}$ " x 0.035 Sqr. Tube	10/28	
1	49216-01	Spacer	304 Stainless Steel, $\frac{1}{2}$ " Rod	8096	
1	84262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	304 Stainless Steel, 0.035" Sheet	3021	
A/R	$\frac{3}{4}$ -16F	Mesh	Expanded carbon steel Stainless	11001	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 90612			
Final Inspection	Drawing 90612			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 84255 Revision 0
Assembly: 84255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	84255-01	Handle Installation			
1	84261-01	Handle Bar Assembly	Below		
2	84267-01	Bracket	Delrin, 3/4" Sheet	WO2010-27	
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	11041	
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	11030	
2	AN3-12A	Bolt -12A		10128	
4	AN3-11A	Bolt		11052	
12	AN960-10	Washer		11028	
6	MS21044N3	Nut		11028	

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 84255			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 84261 Revision 0
Assembly: 84261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
1 Total	36261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	10043	
2	84265-01	Lever	304 Stainless, 0.105 Sheet	10036	
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	11057	
2	MS20615-4M3	Monel Rivet		7039	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84261			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 84262 Revision 0
Assembly: 84262-01 Handle Bracket Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	84261-01	Handle Bracket Assembly			
4	84272-01	Bushing	304 Stainless Steel, 5/16" x 0.058 Tube	8065	
4	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	10037	
2	36275-02	Support	304 Stainless, 5/16" Rod	8065	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84262			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

WO# _____

Approved Manufacturing Facility 73-04



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

90611-01-01

Aircraft:

Robinson

Model: R44

Description:

Basket Body

Supplier:

Aero Design

Color:

White

WO#:

2011-05

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BASKET LID No. of pieces: 1

Manufacturer: AERO DESIGN

Part No.: 90612-01-01 Serial / Batch No.: U/K

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2011-05

Remaining Tasks to be Performed: ASSEMBLY w/ BODY

Signature: JH Cel.

Date: 12 AUG 2013 Lic. No. / ACA AD02

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process
